

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013738**Date Inspected:** 18-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

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This QA inspector observed ZPMC qualified welding personnel identified as 062807 perform Flux Cored Arc Welding (FCAW) Welding on USPL1, weld joint identified as USPL1-514-001 and 002. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062750 perform FCAW Welding on USPL1, weld joint identified as USPL1-512-001 and 002. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform FCAW Welding on USPL1, weld joint identified as USPL1-510-001 and 002. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062761 perform FCAW Welding on

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USPL1, weld joint identified as USPL1-508-001 and 002. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

Outside Yard 10BE

This QA inspector observed ZPMC qualified welding personnel identified as 037996 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 10BE, weld joint identified as OBE1D-015. ZPMC QC is identified as Mr. Wang Xiang Pin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 054013 perform SMAW Welding on OBG Segment 10BE, weld joint identified as OBE1D-016. ZPMC QC is identified as Mr. Wang Xiang Pin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

Outside Yard 9EE

This QA inspector observed ZPMC qualified welding personnel identified as 054014 perform SMAW Welding on OBG Segment 9EE, weld joint identified as CA070-004. ZPMC QC is identified as Mr. Wang Xiang Pin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1368.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 066361 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 12AW, weld joint identified as SEG3004AL-022 and 028. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-Tc-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 067183 perform SMAW Welding on OBG Segment 12AW, weld joint identified as SEG3004AL-023 and 029. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-Tc-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 066326 perform SMAW Welding on OBG Segment 12AW, weld joint identified as SEG3004AL-020 and 026. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-Tc-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 066038 perform SMAW Welding on OBG Segment 12AW, weld joint identified as SEG3004AL-021 and 027. ZPMC QC is identified as Mr. Li Ming Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-Tc-U4b-FCM-1.

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Visual Inspection after Blast

OBG Segment 9CW

This QA Inspector performed a preliminary random visual inspection after the grit blast of the exterior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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| Inspected By: | Kumar,Vibin | Quality Assurance Inspector |
| Reviewed By: | McClendon,Timothy | QA Reviewer |
